

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022597**Date Inspected:** 12-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. An Qing Xing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

OBG Trail Assembly

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3014A-007 located on Side Plate to Bottom Plate of OBG Segment 13BW. ZPMC Welder is identified as 045213. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

SMAW welding of weld joint SEG3015A-012 located on Side Plate to Bottom Plate of OBG Segment 13CW. ZPMC Welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

SMAW welding of weld joint SEG3015A-009 located on Side Plate to Bottom Plate of OBG Segment 13CW. ZPMC Welder is identified as 045213. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

This QA inspector observed ZPMC personnel performed Magnetic particle Testing (MT) on Bottom Plate and

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Side Plate RS stiffener to Floor Beam at panel point 121 cross beam side of OBG Segment 13BW.

This QA inspector observed ZPMC personnel performed Ultrasonic Testing on Floor Beam to vertical Plate at panel point 124 and 124.5 of OBG Segment 13CW. The weld numbers are identifies as SEG3015D-216. See the attached picture.

Bay 14

This QA Inspector observed the following work in progress:

SMAW welding of weld joint SEG3020BB-038 located on Vertical Shear Plate to Anchor Plate of OBG Segment 14W. ZPMC Welders are identified as 037932 and 066261. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3020U-591 located on Anchor Plate to Anchor Plate at panel point 126 of OBG Segment 14W. ZPMC Welders are identified as 066179 and 066361. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3020T-278 located on Deck panel to Anchor Plate at panel point 125.5 of OBG Segment 14W. ZPMC Welder is identified as 045240. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

FCAW welding of weld joint SEG3020R-012 located on Deck panel to Anchor Plate at panel point 126 of OBG Segment 14W. ZPMC Welder is identified as 043433. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

FCAW welding of weld joint SEG3020H-011 located on SA to Deck Panel at panel point 127.3 of OBG Segment 14W. ZPMC Welder is identified as 203871 and 062708. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

FCAW welding of weld joint SEG3020E-017 located on Deck panel Diaphragm to Deck Panel Diaphragm at panel point 128.3 of OBG Segment 14W. ZPMC Welder is identified as 201215. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

SMAW welding of weld joint SEG3020C-029 located on Floor Beam to SA at panel point 128.7 of OBG Segment 14W. ZPMC Welders are identified as 045246 and 067942. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3020E-015 located on Floor Beam to SA at panel point 128.7 of OBG Segment

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14W. ZPMC Welder is identified as 069896. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer